

Date: Friday, 2/23/2007 1:47:59 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MID TUBE ASSEMBLY
Job Number	: 30927		
Estimate Number	: 10469		
P.O. Number	: <i>N/A</i>	Part Number	: D3391023
This Issue	: 2/23/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3391 UNDER REVIEW <i>PH 07.02.26</i>
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 29209	Drawing Revision	: E
		Material	: <i>N/A</i>
		Due Date	: 3/21/2007
Written By	:	Qty:	1 Um: Each
Checked & Approved By	: <i>[Signature]</i> <i>07.02.26</i>		
Comment	: Est. A 05.10.20 New Issue KJ/EC		
	: Est. B 06.02.10 ECN773 dwg rev.D EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D25001100	Skidtube Extrusion
-----	-----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-100	Extrusion	<i>B24593 BE 07-02-27</i>

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 as per Dwg D3391

4-Open float bag holes to Ø0.250" as per Dwg D3391 using DT8796D visual aid Jig

5-C'sink float bag holes as per Dwg D3391

6-Open remaining holes to Ø0.375"

7-Remove .030" from Fwd indexing Ridge as per Dwg D3391

8-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

9-Deburr

10-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

11-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg

D3391 and 2 holes in section Detail "J"

12-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.250" and c'sink (20 holes) as per Dwg D3391

13-Open .375" holes to .438"

14-Deburr and blow out all chips from inside tube

BE 07-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 30927

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD 7-3-2

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pin 07-03-05

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07-03-14

6.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Pick:

Qty

Part Number

Description

Batch

1

D3389-1

Web

B30790

A/R

Sikaflex-241/-291

m103487

Sikaflex expire date:

67-10-01

Start: *07-03-14* Time: *7:30 am*

Finish: *07-03-19* Time: *10:30 am*

Pin 07-03-14

(Pin)

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

Pin 07-03-14

8.0

POWDER COATING

POWDER COATING



M 103706



(1)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l 07/03/31

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



m-l 07 04 02



(1)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-023 PAR #: NA Fault Category: Pod/Landing Gear NCR: Yes No Q DQA: Q Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR: <u>30927</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/14	6.0	1x 3389-1 is scrap. For some reason the one of the fuel holes is a 1/2" off center. Pins don't pass through.	<i>[Signature]</i> 07/03/14	Scrap: destroy: replace. Ensure when webs are made i. inspected check the holes are all centered.	<i>[Signature]</i> 07-03-14	<i>[Signature]</i> 07/03/14	<i>[Signature]</i> 07/03/14	<i>[Signature]</i> 07/03/14
07/04/02	10.0 11.0	Mixed up inserts NAS133C3KB166 NAS133C3KB116	<i>[Signature]</i> 07/04/02	Drill out inserts and replace with the correct insert	<i>[Signature]</i> 07/04/02	<i>[Signature]</i> 07/04/02	<i>[Signature]</i> 07/04/02	<i>[Signature]</i> 07/04/02

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 1:47:59 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 30927

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

NAS1330C3KB116

Insert



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Insert

Pick:

Qty

Part Number

Description

Batch

40 ~~20~~

NAS1330C3KB116

Insert

M101396

~~M100732~~

M.A 07/04/02

11.0

NAS1330C3KB166

INSERT



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

RivnuT

Pick:

Qty Part Number

Description

Batch

20 ~~10~~

NAS1330C3KB166

Insert

M100732

~~M101396~~

M.A 07/04/02

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Install inserts as per Dwg D3391

M.A

07/04/02

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

Force

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

M.A B30309

07/4/4

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
07/04/05

Job Completion



u 07.04.04

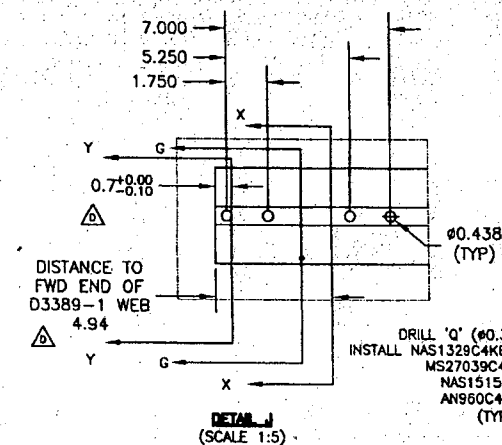
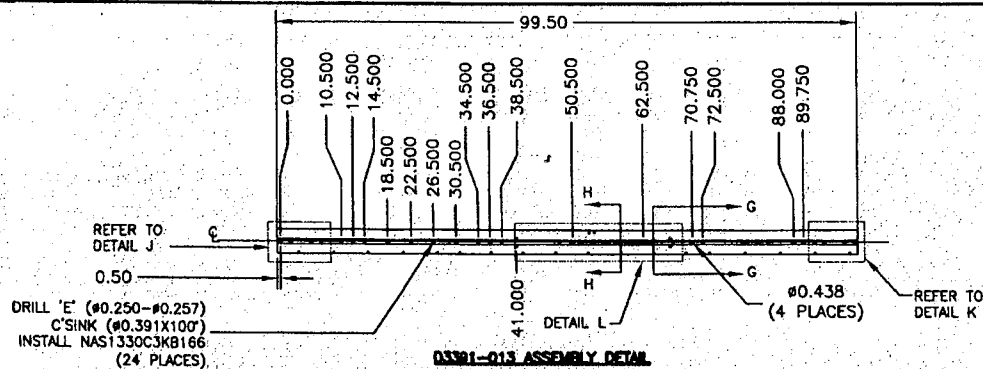
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

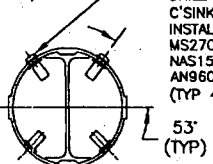
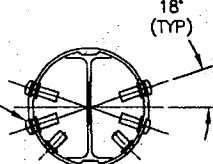
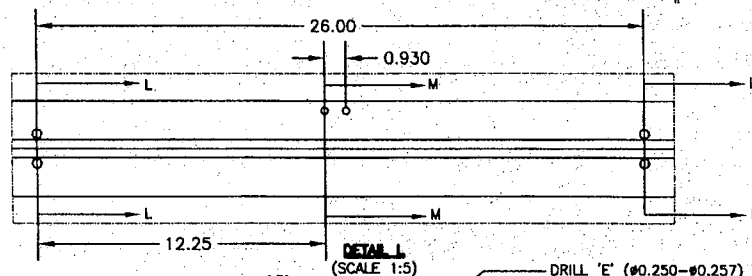
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

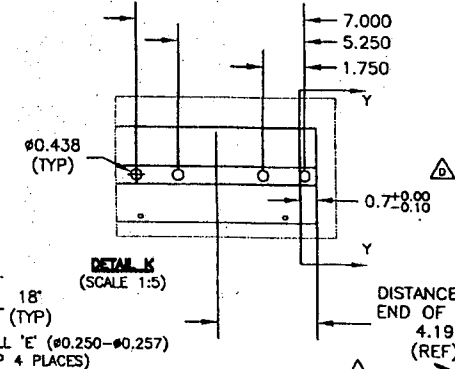
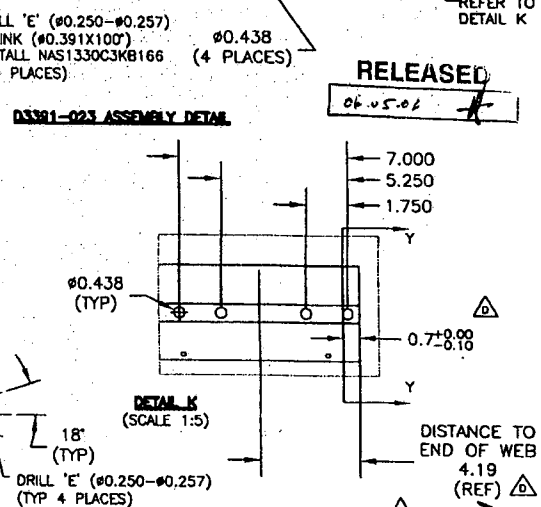
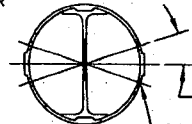
NOTE: Date & initial all entries



DRILL 'Q' (#0.332-#0.338)
INSTALL NAS1329C4KB140 INSERT
MS27039C4-08 SCREW
NAS1515H4L WASHER
AN960C416L WASHER
(TYP 4 PLACES)



DRILL 'E' (#0.250-#0.257)
C'SINK (#0.391X100')
INSTALL NAS1330C3KB116 INSERT
MS27039C1-09 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 4 PLACES)



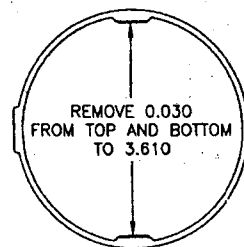
RELEASED
06.05.06

D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/293 PER 05-07-01

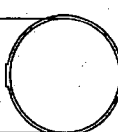
SECTION L-L
(SCALE 1:4)



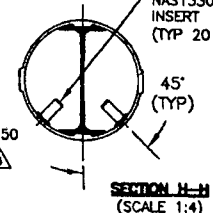
SECTION X-X
(SCALE 1:2)

REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)

SECTION Y-Y
(SCALE 1:4)



SECTION G-G
(SCALE 1:4)



SECTION H-H
(SCALE 1:4)

NAS1330C3KB116
INSERT
(TYP 20 PLACES)

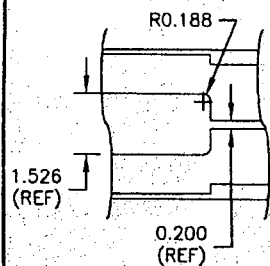
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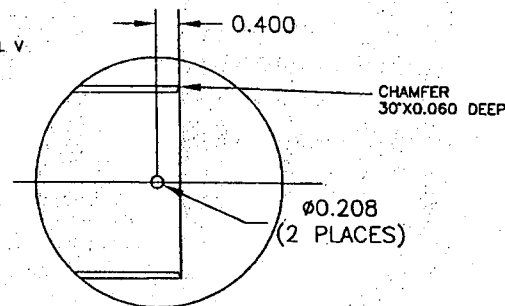
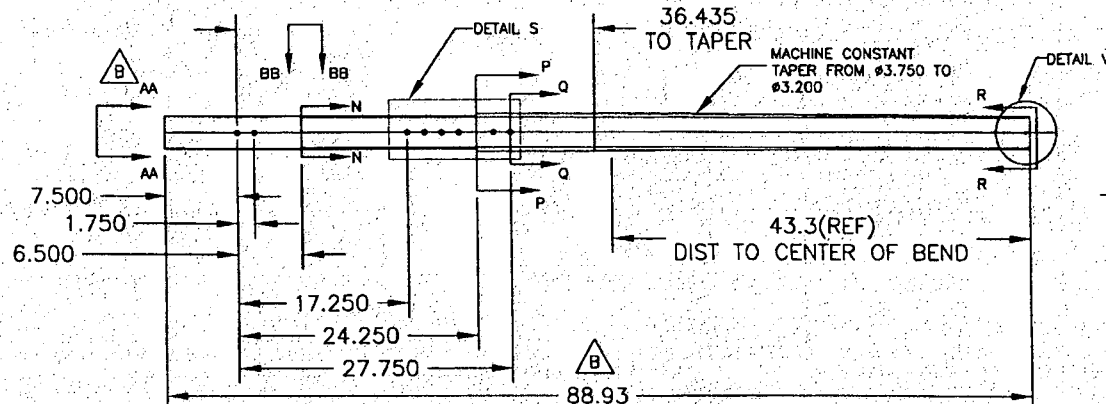
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, OH	REV. E
CHECKED #	APPROVED #	DRAWING NO. D3391	SHEET 3 OF 5
DATE 06.04.25	TITLE 412 FLOAT SKIDTUBE	SCALE 1:20	

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBMIT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
30927

UNDER REVIEW
07.11.06
02.02.06
PH

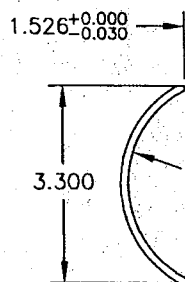


VIEW BB-BB
(SCALE 1:3)

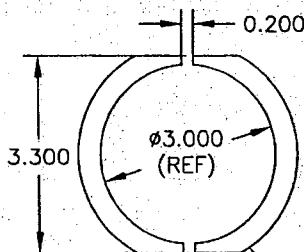


DETAIL V
(SCALE 1:2)

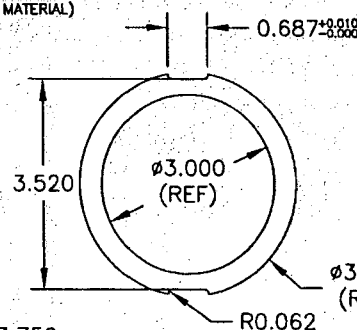
Ø3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



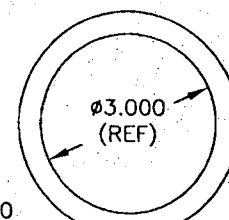
SECTION AA-AA
(SCALE 1:2)



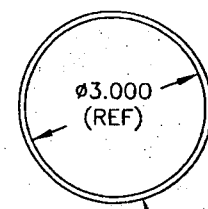
SECTION N-N
(SCALE 1:2)



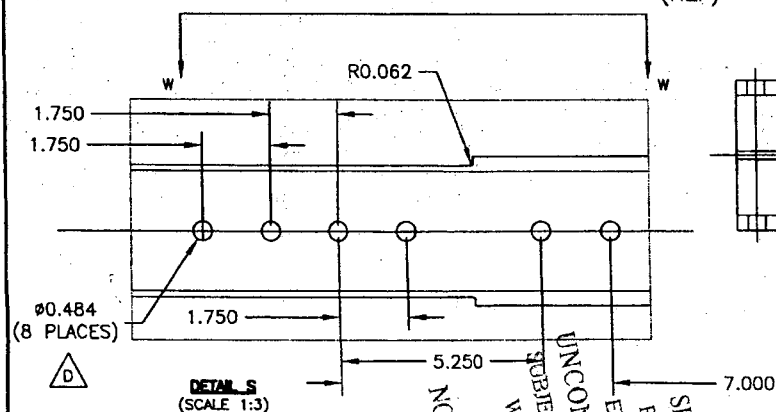
SECTION P-P
(SCALE 1:2)



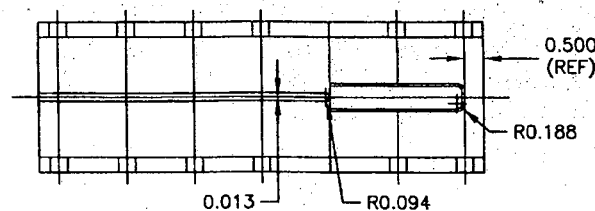
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



VIEW W-W
(SCALE 1:3)

07.02.26 PH
UNDER REVIEW
~~07.01.15 OLL~~

RELEASED

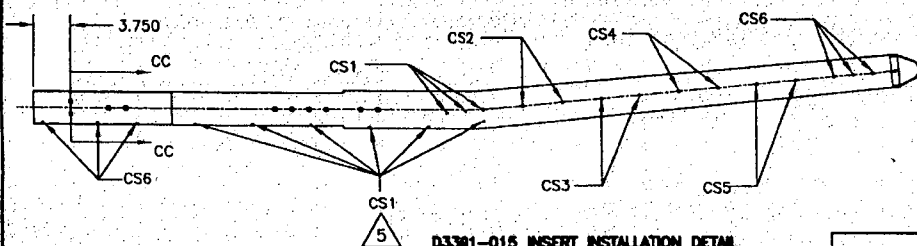
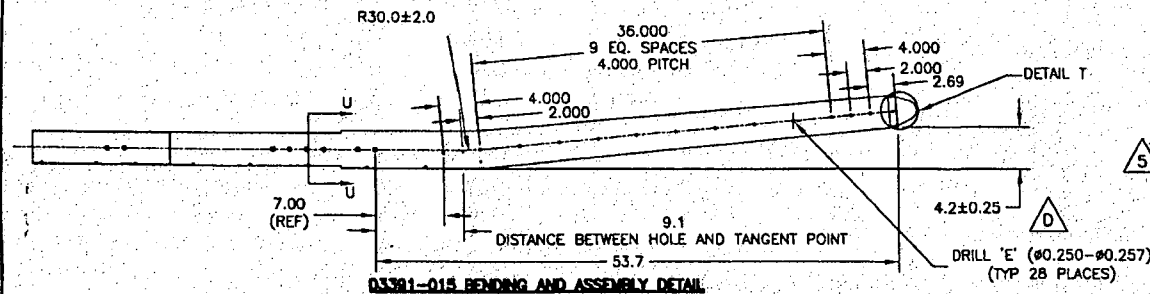
26.05.03

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DESIGN	PH	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. E
CHECKED	#	APPROVED	#	DRAWING NO. 03391	SHEET 4 OF 5
DATE	06.04.25	TITLE	412 FLOAT SKIDTUBE	SCALE	1:12

NO
WORK ORDER
30927
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
RETURN TO
ENGINEERING
SHOP COPY

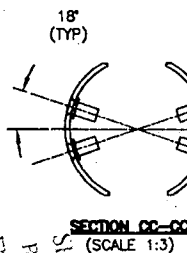


C'SINK AND INSTALL AESS10KBXXX AND/OR NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

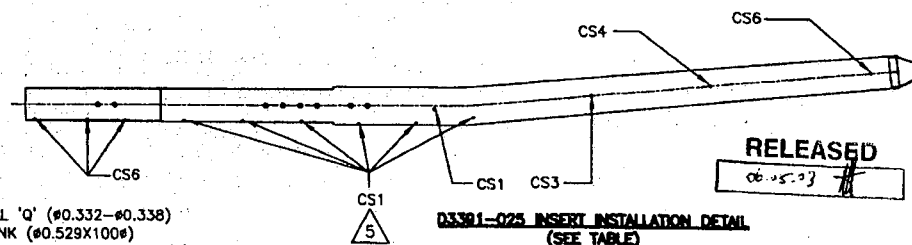
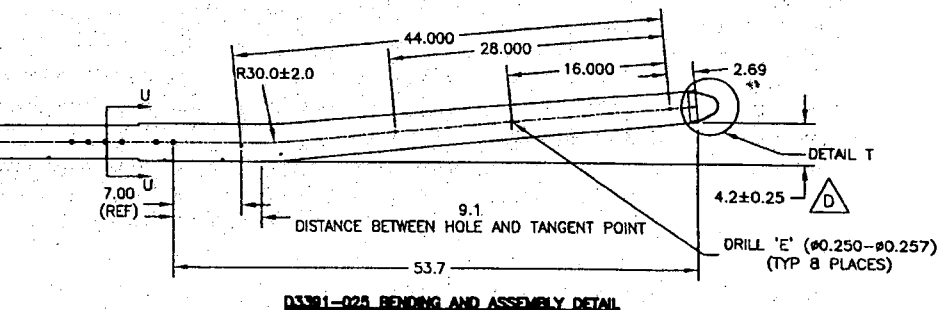
HOLE MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	AESS10KB398
CS2	2	2	Ø0.391	AESS10KB398
CS3	2	2	Ø0.391	NAS1330C3KB316
CS4	2	2	Ø0.391	NAS1330C3KB266
CS5	2	2	Ø0.391	NAS1330C3KB216
CS6	12	8	Ø0.391	NAS1330C3KB166

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
10	14	AESS10KB398	INSERT
4	2	NAS1330C3KB316	INSERT
4	2	NAS1330C3KB266	INSERT
4	2	NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4	2	NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER



DRILL 'Q' (#0.332-#0.338)
C'SINK (#0.529X100#)
NAS1330C4KB151 INSERT (1)
(4 PLACES)



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DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	APPROVED	DRAWING NO. D3391
DATE 06.04.25	TITLE 412 FLOAT SKIDTUBE	REV. E SHEET 5 OF 5 SCALE 1:12

UNDER REVIEW
07.02.16
PH

SEAL WITH
SIKAFLEX-241/-291

RELEASED
06-05-03

WORK ORDER
30927
CONTROLLED COPY
RETURN TO
ENGINEERING
WITHOUT NOTICE

